

5/45

DART AEROSPACE LTD	Work Order:	24560
Description: Backing plate	Part Number:	D2228
Drawing: D2228 rev. A/B	Qty:	100 30

05.10.13 11-12

42

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	OK	05.10.13	100 30
2	METAL	Make as per Dwg D2228 Material: 5052-H32 0.063" thick	FF	05/11/14	42 30
3	METAL	Deburr	FF	05/11/14	42
4	QC	Inspect Level 5	2	05/11/20	40 PTO
5	FINISHING	Chemical conversion coat as per QSI 005	PL	05/12/14	40
6	FINISHING	Powder coat white as per QSI 005 ( ref. 4.3.5.1)	Am	06/02/20	40
7	QC	Inspect Level 3	FC	06/02/20	40
8	STORES	Identify and stock	ST 31	6/2/21	40
9	EXPEDITING	Close W/O Cost / part 5uc 06/02/22 (40)	OK	06/02/20	40

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Rev	Date	Change	Revised By	Approved
A				
B	00.08.22	Re-format	EC	

RELEASED

EC 00.08.24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
05-11-28	2	2 parts are 0.15" too wide causing holes to be too far apart	AB QPPD	Scrap & destroy	05-11-28	05-11-28	AB QPPD	05-11-28	

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA: \_\_\_\_\_

Date: 06/12/22

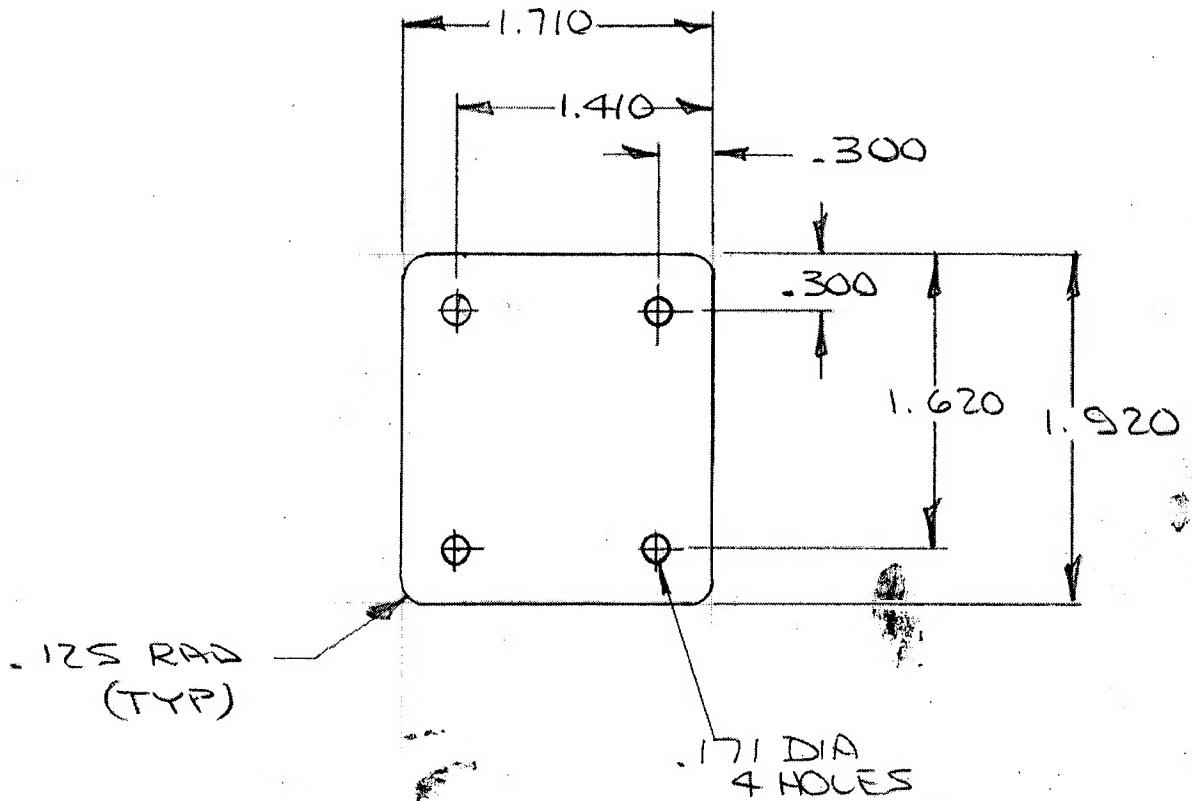
NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

**DART**COPY  
RELEASER

DRAWN BRADLEY 94.3.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.23	DRAWING NO. D2228	REV. B SHEET 1 OF 1
STRESS	TITLE BACKING PLATE	
B 00.09.11	UPDATE FINISH SPEC. & CP	

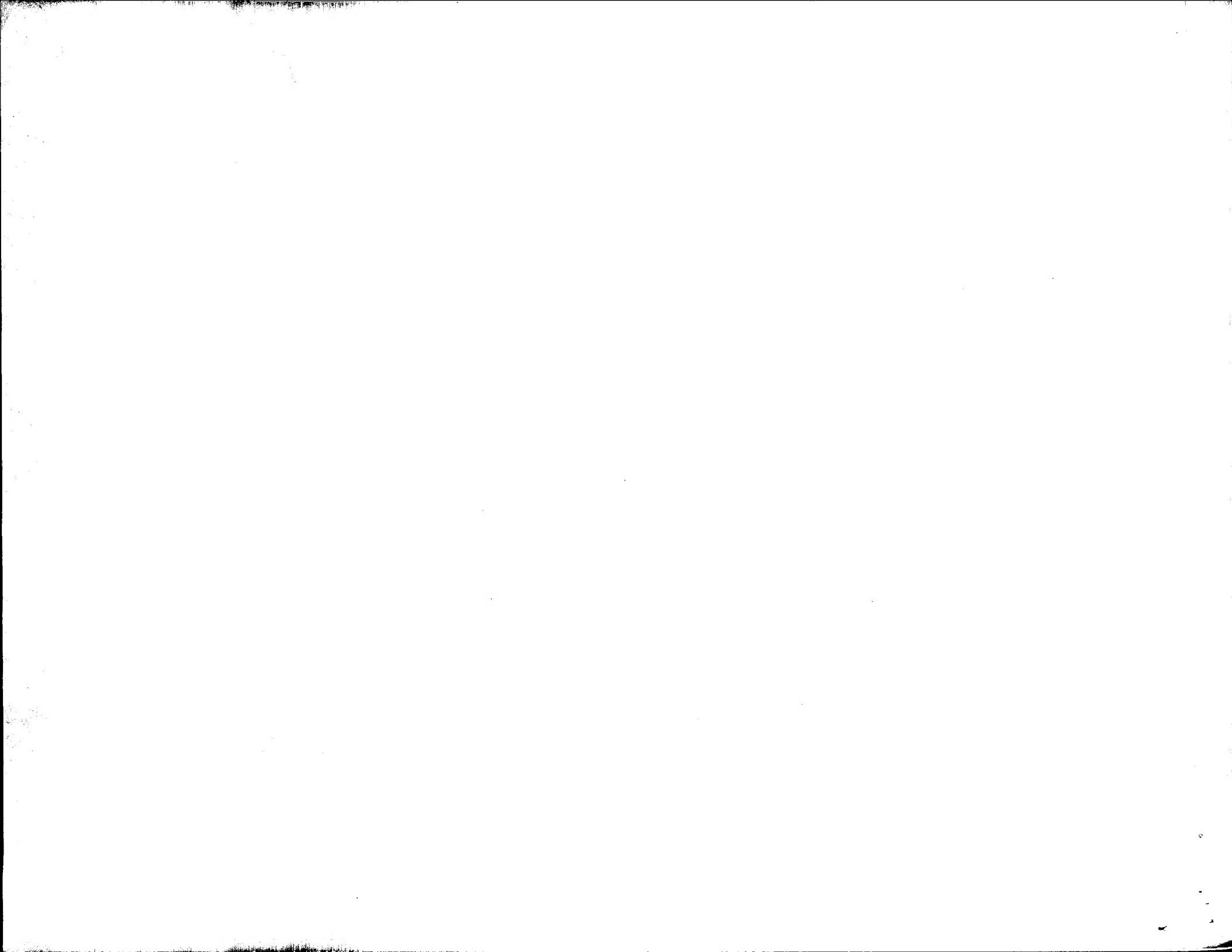
**RELEASED**  
00.09.12

MATERIAL: 5052-H32 .063 THICK  
(QQ-A-250/8)

FINISH: A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

UNDER

NO. 24560



## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyOct 13, 2005  
11:58 am

Work Order No : 0024560  
 Project Name : D2228  
 Project For : WK545  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2228  
 Description : Backing Plate  
 Manufactured : Yes  
 Amount Req'd : *100 30 42*  
 Amount Done : 0  
 Start Date : 10-13-05  
 Est Finish Date : 11-15-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden	0.00	0.00	0.00		
=====		=====	=====		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
12:23 pm

Work Order No : 0024560  
 Project Name : D2228  
 Project For : WK545  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2228  
 Description : Backing Plate  
 Manufactured : Yes  
 Amount Req'd : 30  
 Amount Done : 0  
 Start Date : 10-13-05  
 Est Finish Date : 11-15-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

MIS Job  
W  
11/15

Date: Monday, 14/11/2005 3:44:54 PM  
 User: Alba Panzuto

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACKING PLATE		
Job Number	: 24560		Part Number	: D2228		
Estimate Number	: 10506		Drawing Number	: D2228 REV. B		
P.O. Number	:		Project Number	:		
This Issue	: 14/11/2005	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 30/11/2005 Qty: 30 Um: Each		
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est:B 00.08.22 Re-format EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
2.0	SHEAR	SHEAR
<b>Comment:</b> SHEAR Cut blank: 1.710" x 1.920"		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
6.0	POWDER COATING	POWDER COATING
<b>Comment:</b> POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION		

Date: Monday, 14/11/2005 3:44:55 PM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKING PLATE

Job Number: 24560

Part Number: D2228

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

